



# CEWELD E HGW

TYPE	Covered electrode for cold welding dirty and old cast Iron parts										
TOEPASSINGEN	E HGW is recommended for welding cast iron that require the same colour at the repair area and in case Nickel or Fe-Nickel electrodes fail to offer proper bonding properties. Often used as buffer layer prior to Ni. or NiFe types.										
EIGENSCHAPPEN	Easy to apply and excelent for use on dirty and old cast iron parts that are difficult to weld (bonding problems). The weld deposit can be machined by grinding and is not corrosion resistant.										
CLASSIFICATIE	AWS A 5.15: ESt										
GESCHIKT VOOR	cast iron										
GOEDKEURINGEN											
LASPOSITIES											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><thead><tr><th>C</th><th>Si</th><th>Mn</th><th>Fe</th></tr></thead><tbody><tr><td>0.2</td><td>0.1</td><td>0.7</td><td>Rem.</td></tr></tbody></table>	C	Si	Mn	Fe	0.2	0.1	0.7	Rem.		
C	Si	Mn	Fe								
0.2	0.1	0.7	Rem.								
MECHANISCHE WAARDEN	<table><thead><tr><th>Heat Treatment</th><th>R<sub>p0,2</sub> (MPa)</th><th>R<sub>m</sub> (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td></td><td></td><td></td><td>180 HB</td></tr></tbody></table>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness	As Welded				180 HB
Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness							
As Welded				180 HB							
HERDROGEN	Not required										
GAS ACC. EN ISO 14175											